

Split

Work Order ID 67787-1

Wednesday, March 30, 2011 11:34:12 AM



Item ID: D3121-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 3/30/2011 Start Qty: 12.00

Required Date: 4/4/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date: 3/30/11 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100



Bandsaw

Jcaspa Bandsaw

BAND SAW

Memo

Cut blanks (1.250" x 2.000") 6.600" long

0.00

0.00

[Signature] 3/30/11

12 *[Signature]*

110



HAAAS 1

HAAAS CNC vertical machine #1

HAAAS CNC VERTICAL MACHINING #1

Memo

1-Machine D3121-111 as per Folio FA361 and Dwg D31211 identify as D3121-111 2-Debur 3-Scribe batch number

0.00

0.00

[Signature] 3/30/11

12 *[Signature]*

120



QC

Quality Control

QC2- Inspect parts off machine FA1/FA1B

Memo

0.00

0.00

[Signature] 3/30/11

12 *[Signature]*

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Page 2

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC 8- Inspect parts - second check

0.00

SL

11/04/13

(12)

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

Small Fab

Memo

0.00

SS 11/04/15

(3)

Small Fab

Assemble D3121-141 as per Dwg D3121

150

QC 8- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

ml 11 04 15 (3)

Quality Control

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Page 3

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Identify as per dvg & Stock Location: 235A

0 00



Packaging

Memo

0 00

Packaging

11/4/15 30

170

QC21- Final Inspection - Work Order Release

0 00



QC

Memo

0 00

Quality Control

11/4/18
ME
11-04-15

Picklist Print

Wednesday, March 30, 2011 11:34:17 AM

Work Order ID: 67787

Parent Item: D3121-141

Parent Item Name: Bracket Assembly

Start Date: 3/30/2011

Start Qty: 12.00

Required Date: 4/4/2011

Required Qty: 12.00

Comments:

IPP Rev: Pick: A 04.02.18 New issue KJ/DS
 IPP Rev: B ECN 1060 07-11-12 DD verified by: EC
 IPP Rev: C New Dimensions for Blank Size 08-07-23 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3121-241



Bracket Assembly

Manufactured No

100

Each

16.0000

1

12



SB 11/04/15

(12)

Location

Loc Qty

Loc Code

ST235A

B67776

16

66163

1

67280

15

140

Each

0.0000

1

12



(3)

SB 11/04/15

(3)

D3121-21



Bolt

Manufactured No

140

Each

0.0000

1

12



(3)

SB 11/04/15

(3)

M17-1111.250X02.000



17-1 SN Bar 1.250 X 2.00

Purchased No

140

f

18.4000

0.55

6.947368



Location

Loc Qty

Loc Code

MAT050

18.4

114899

2

B115806

16.4

6.94 SB 11/04/11

DART AEROSPACE LTD		Work Order: 67787
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

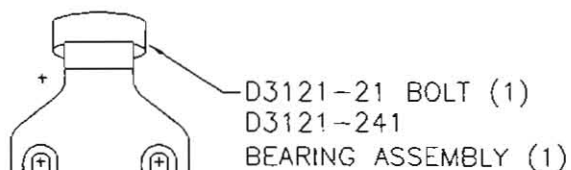
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.3927	—		Micr ML-08	
0.75	+/-0.030	.749	—		Vern ML-7	
0.375	+/-0.010	.374	—		"	
2.14	+/-0.030	2.130	—		"	
1.96	+/-0.030	1.964	—		"	
0.280	+/-0.010	.270	—		"	
3.330	+/-0.010	3.320	—		"	
3.630	+/-0.010	3.620	—		"	
R0.25	+/-0.030	R.250	—		Rad-gage	
R0.375	+/-0.010	R.375	—		"	
Ø0.201	+0.005/-0.001	0.200	—		Vern ML-7	
0.100	+/-0.010	.098	—		"	
4.580	+/-0.010	4.571	—		"	
6.18	+/-0.030	6.182	—		Vern CML-02	
5.89	+/-0.030	5.880	—		"	
0.080	+/-0.010	.077	—		Vern ML-7	
0.300	+/-0.010	.300	—		"	
30°	+/-0.1°	30°	—		C-square	
R0.25	+/-0.030	R.250	—		Rad-gage	
0.130	+/-0.010	.125	—		Vern ML-7	
0.664	+/-0.010	.664	—		"	
0.381	+/-0.010	.391	—		"	
0.201	+/-0.010	.200	—		"	
0.400	+/-0.010	.397	—		"	
0.580	+/-0.010	.596	—		"	
100°	+/-0.1°	100°	—		"	
0.032	+0.000/-0.010	.026	—		Depth gage ML-05	

Measured by: <i>gml</i>	Audited by: <i>SL</i>	Prototype Approval:	N/A
Date: 11/04/12	Date: 11/04/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	

DART

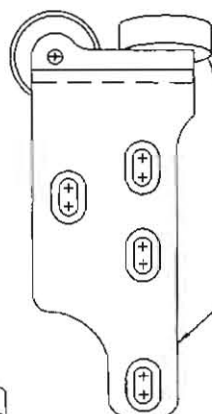
DESIGN <i>[Signature]</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

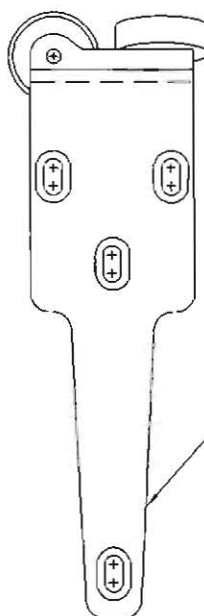
D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07 *[Signature]*



D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)

D3121-115/-116
BRACKET

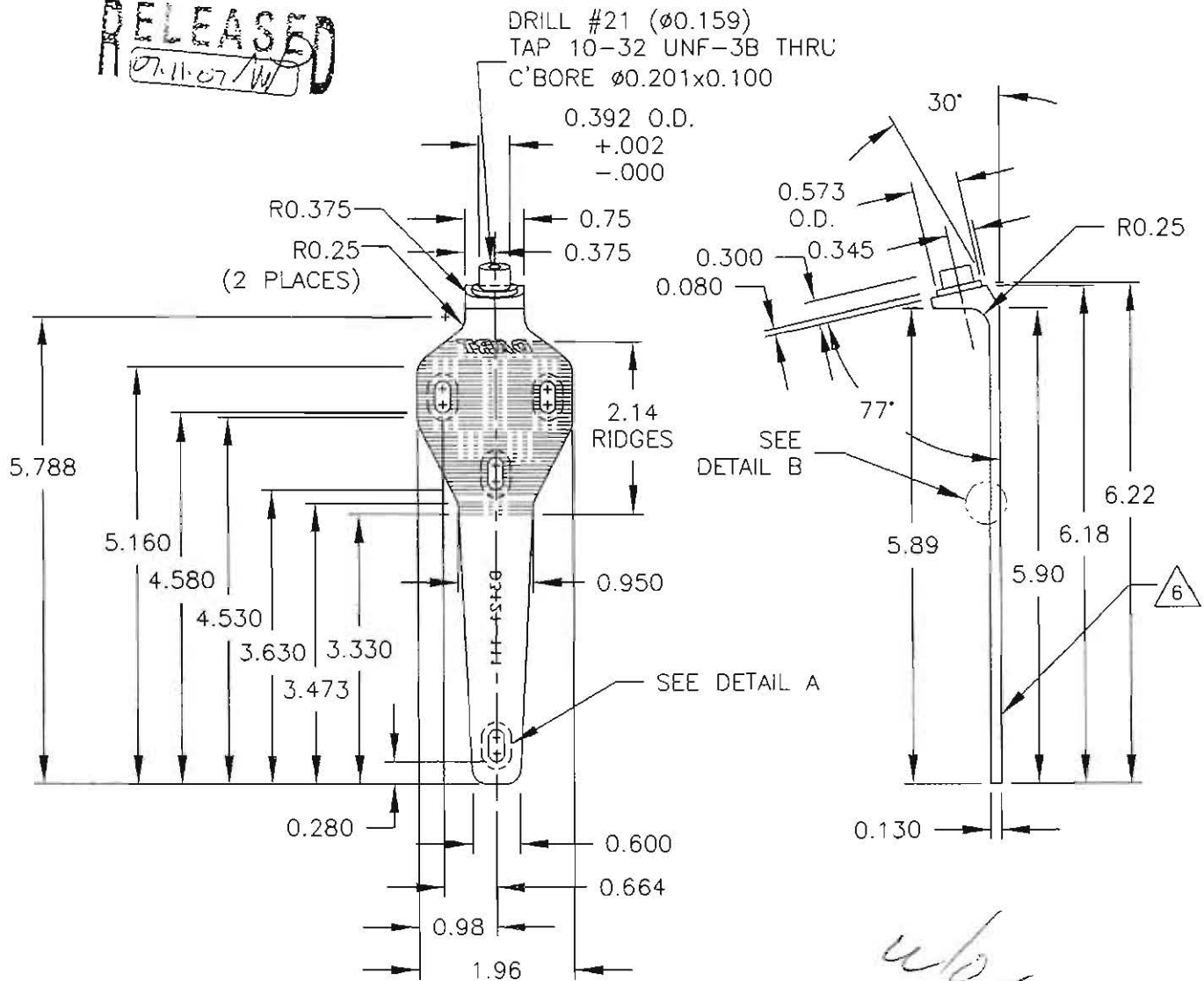
D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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DART

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO D3121	REV. E SHEET 7 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07/W**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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